

slp 18/05

Date: Thursday, 5/10/2007 2:23:38 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARSHOE
Job Number	: 32268		
Estimate Number	: 12737		
P.O. Number	: <i>N/A</i>	Part Number	: D353513
This Issue	: 5/10/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3535 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: <i>AB</i> # 07.05.10
Previous Run	: <i>N/A</i>	Material	: <i>N/A</i>
Written By	:	Due Date	: 5/17/2007 Qty: 4 Um: Each
Checked & Approved By	: <i>[Signature]</i> 07.05.10		
Comment	: Est Rev:A New Issue 07-02-15 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 0.8930 sf(s)/Unit Total : 3.5721 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: *M101264 CW M101873 (3)*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: *AB*

Prog Rev: *B*

2-Deburr if necessary

NOTE: Check Rev of DWG and float pattern

SAD 07/05/12
[Signature] 07/05/15

(4) *(4)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/05/12

(4)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

[Signature] 07.05.15 *(4)*

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326

2-Form joggle as per Dwg D3535 using Jig DT8158 Identify as D3535-13

MF 07-05-16 *(4)*
MF 07-05-16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 2 Date: 07/05/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/10/2007 2:23:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 32268

Part Number: D353513

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/05/16 (4)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M101601

07-05-17 (4)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/05/18 (4)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/05/18 (4)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/18 (4)

Job Completion



07-05-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

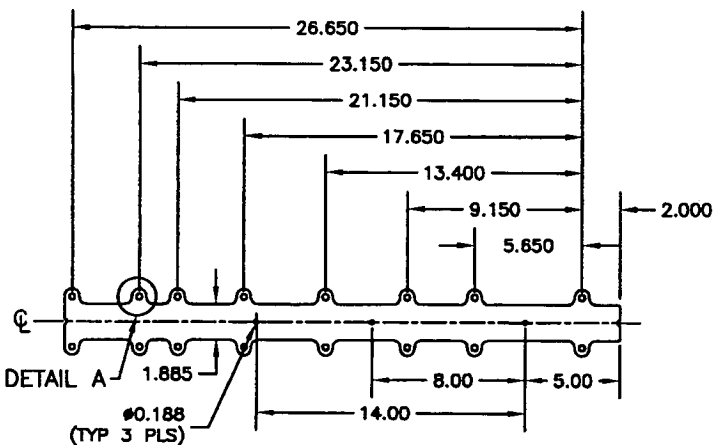
NOTE: Date & initial all entries

DART

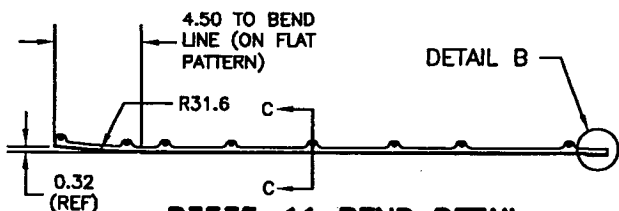
RELEASED

07.04.24

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE		TITLE
07.04.17		WEARSHOE
		SCALE
		1:10
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

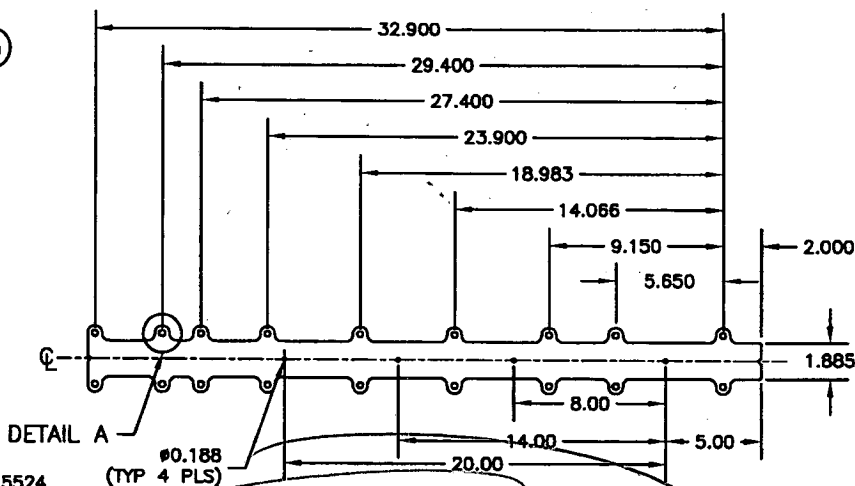


D3535-11F FLAT PATTERN

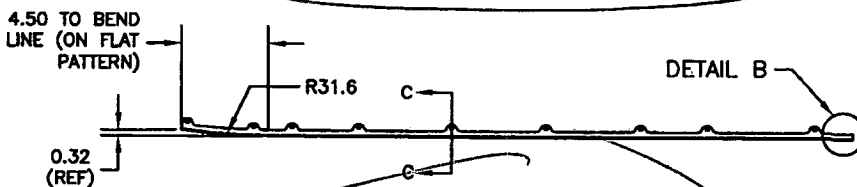


D3535-11 BEND DETAIL

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NO. 32208



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

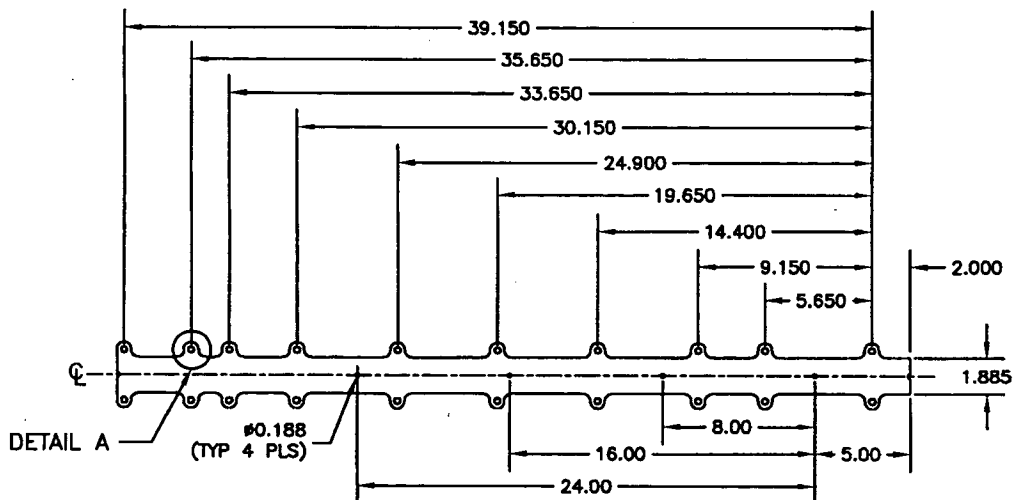
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DART

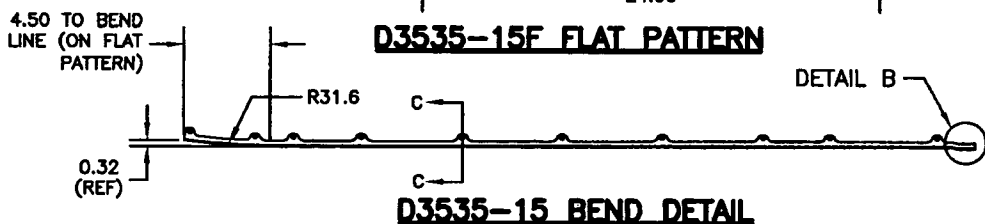
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07.04.24

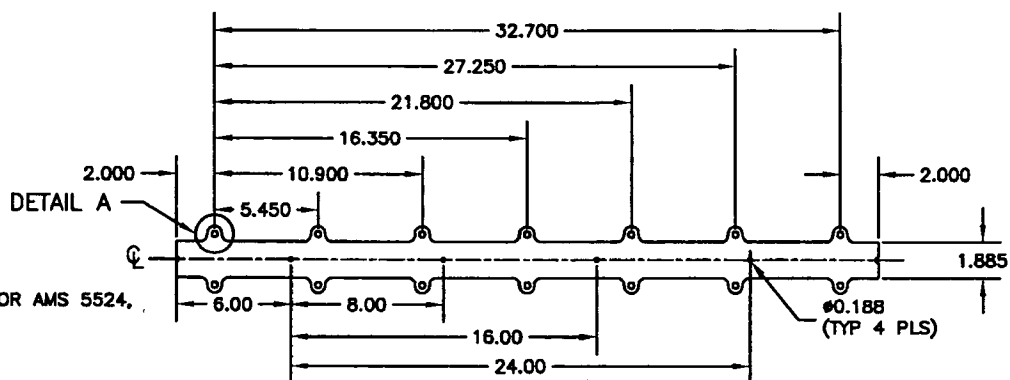
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. B
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 2 OF 7
DATE		D3535	SCALE
07.04.17		WEARSHOE	1:10



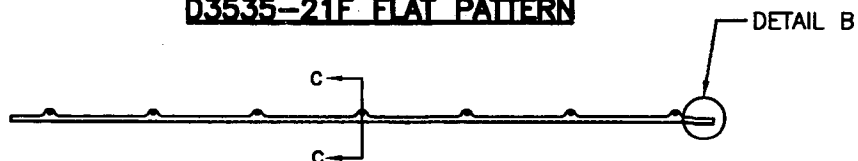
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

NOTES

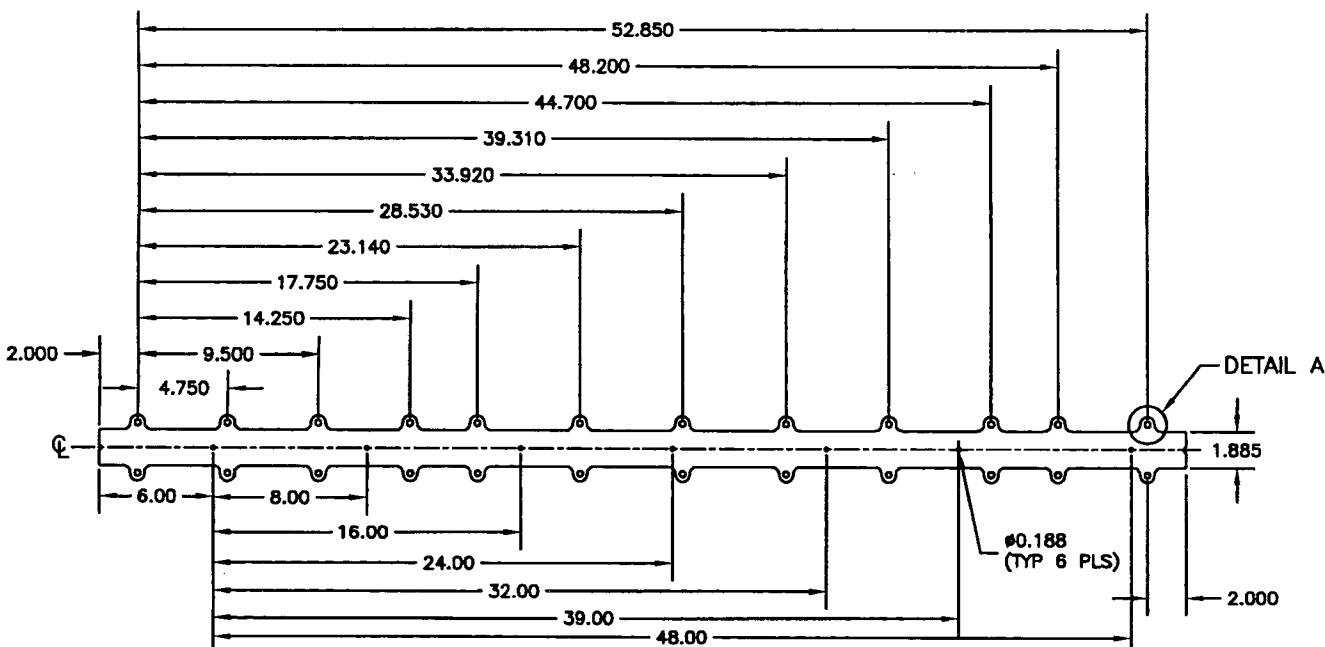
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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WORK ORDER
NO. 32268

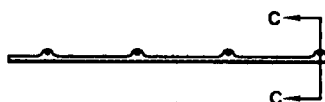
DART

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07.04.24



D3535-23F FLAT PATTERN

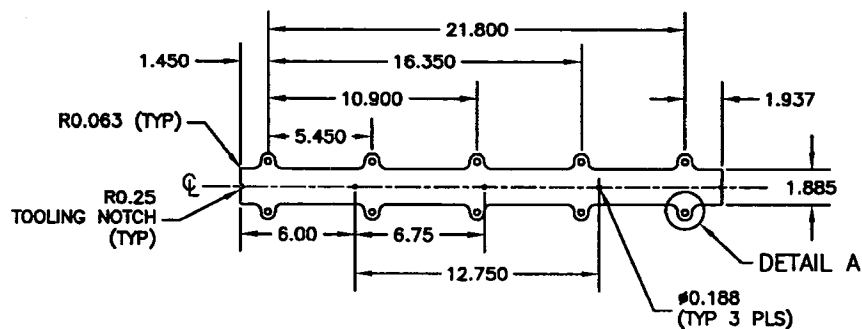


D3535-23 BEND DETAIL

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NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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- 8) SEE PAGE 7 FOR DETAILS AND SECTION



D3535-25F FLAT PATTERN



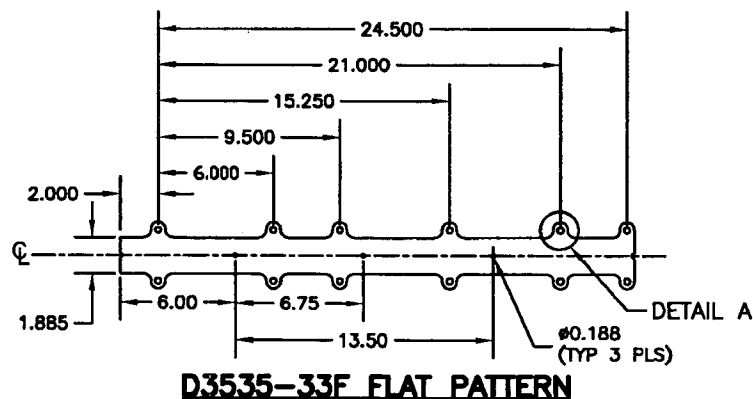
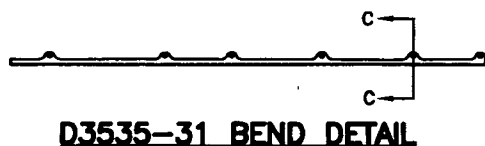
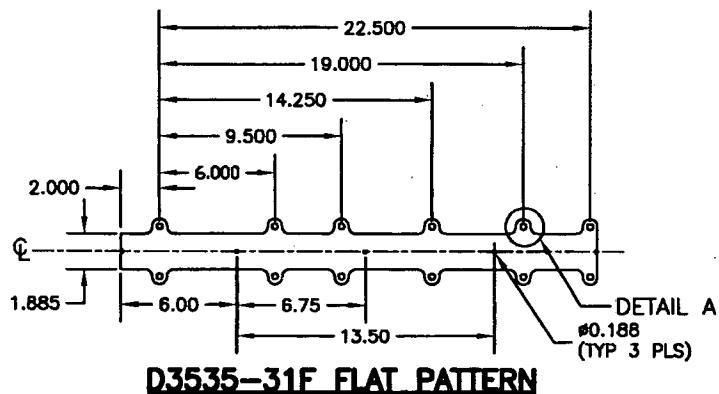
D3535-25 BEND DETAIL

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
#	#	D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 3 OF 7
		SCALE 1:10

DART

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07.04.24

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CB	PH	DRAWING NO.	REV. B	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	D3535	SHEET 4 OF 7	
DATE 07.04.17	TITLE WEARSHOE		SCALE 1:10	



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NOTES

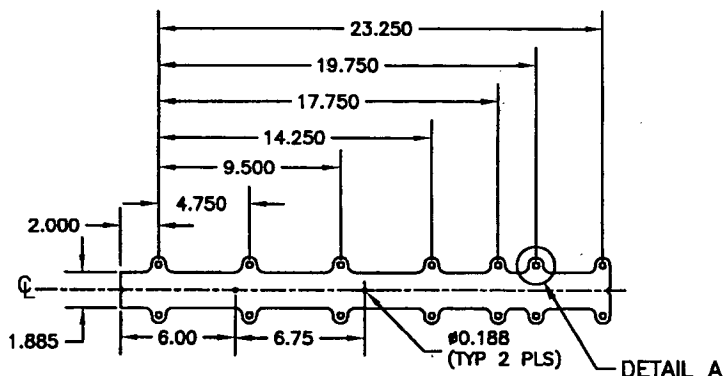
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- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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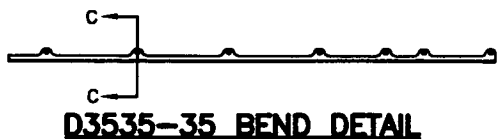
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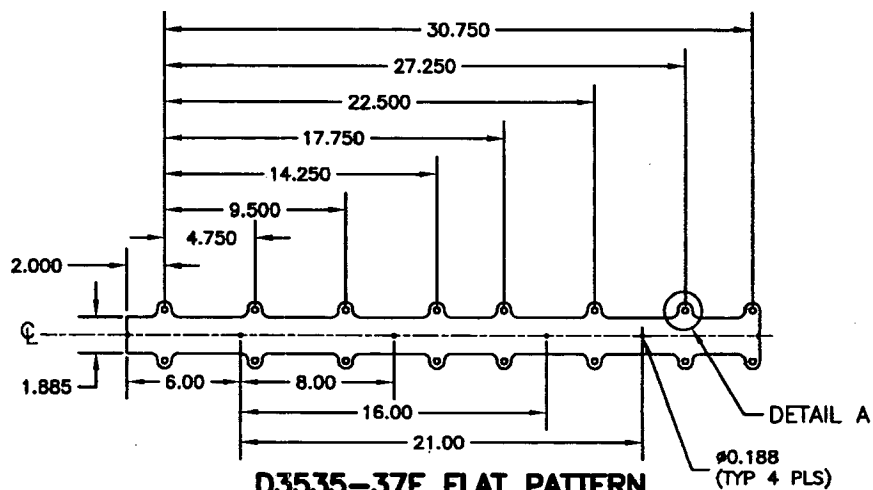
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 5 OF 7
		SCALE	1:10	



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
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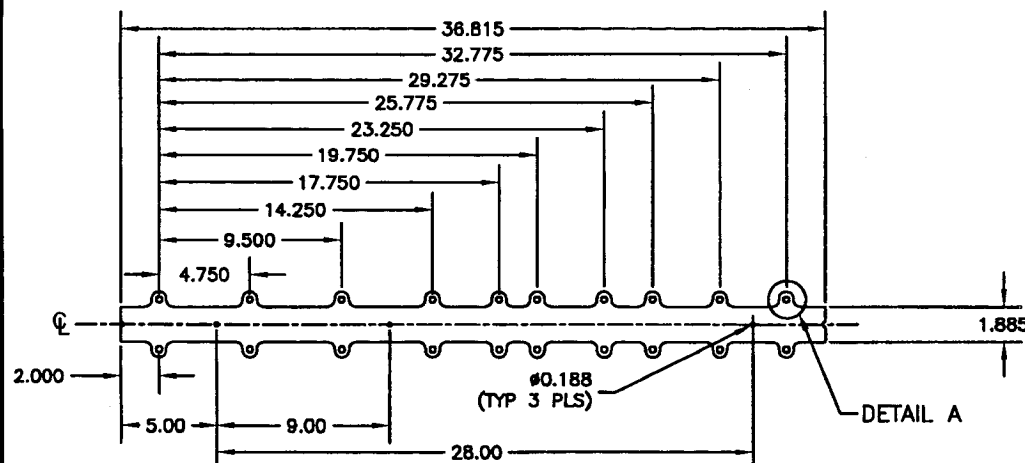
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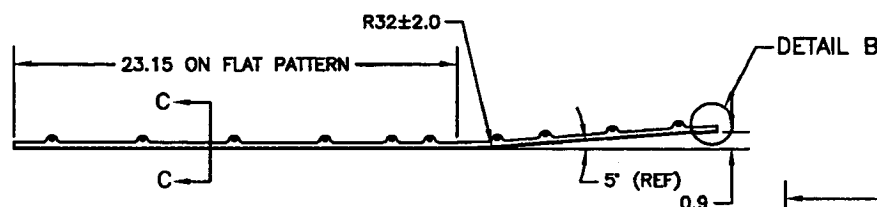
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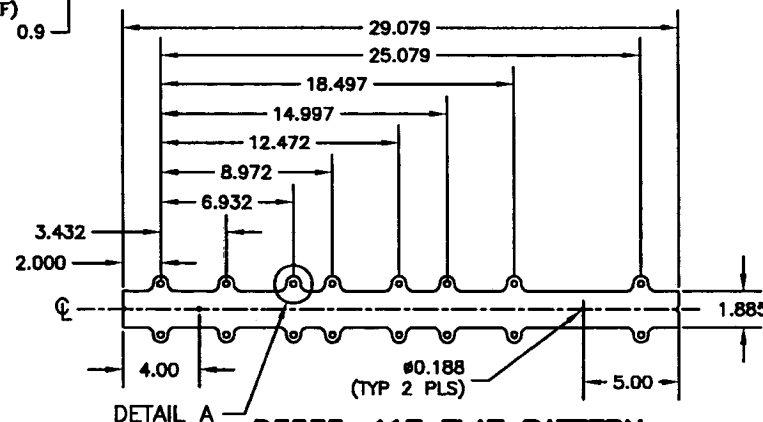
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 6 OF 7
		SCALE	1:10	



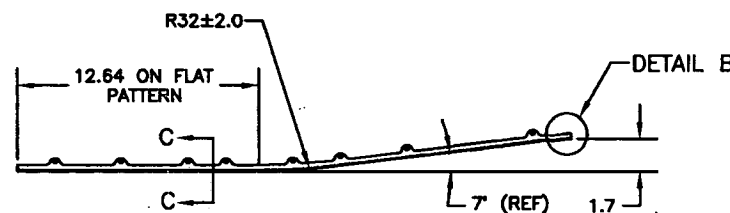
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

NOTES

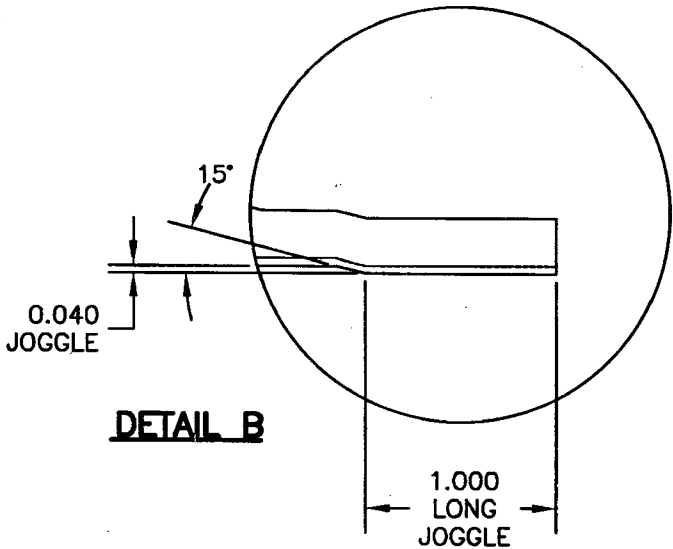
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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WORK ORDER
NO. 32268

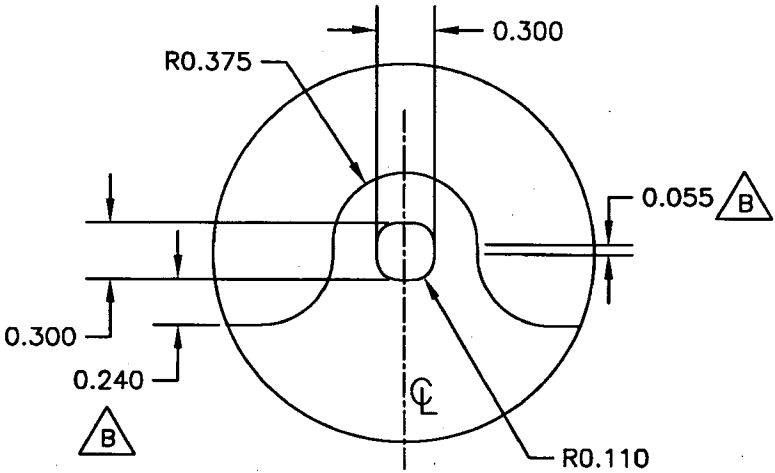


DESIGN	C.B.	DRAWN BY	PH	DART AEROSPACE USA, INC.
				PORT HADLOCK, WA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3535
DATE	07.04.17			SHEET 7 OF 7
				SCALE 1:1
				TITLE WEARSHOE

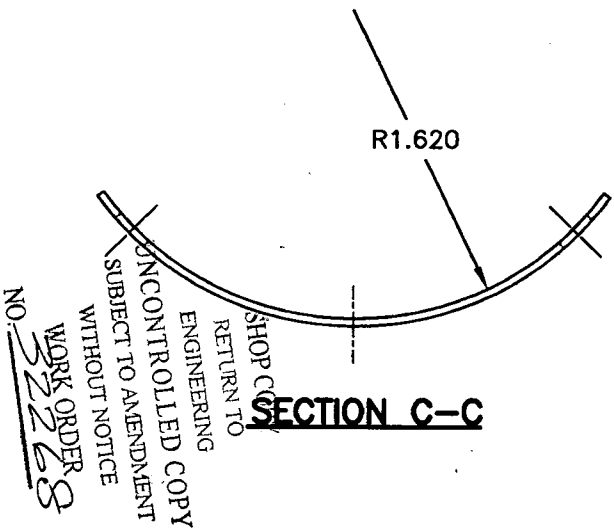
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07.04.24 *[Signature]*



DETAIL B



DETAIL A



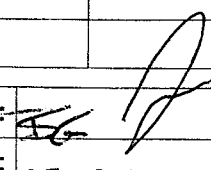
SECTION C-C

DART AEROSPACE LTD		Work Order:	
Description: Bear paw wear shoe		Part Number:	D3535-73
Inspection Dwg: D3535 Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	32.900	+/-0.010	32.900	✓		M-T	
B	29.400	+/-0.010	29.400	✓		M-T	
C	27.400	+/-0.010	27.400	✓		M-T	
D	23.900	+/-0.010	23.900	✓		M-T	
E	18.983	+/-0.010	18.980	✓		M-T	
F	14.066	+/-0.010	14.060	✓		M-T	
G	9.150	+/-0.010	9.149	✓		Vern	
H	5.650	+/-0.010	5.648	✓		Vern	
I	2.000	+/-0.010	2.007	✓		Vern	
J	1.885	+/-0.010	1.889	✓		Vern	
K	5.00	+/-0.030	5.00	✓		Vern	
L	8.00	+/-0.030	8.00	✓		Vern	
M	14.00	+/-0.030	13.99	✓		Vern	
N	20.00	+/-0.030	19.99	✓		Vern	
O	0.300	+/-0.010	0.295	✓		Vern	
P	0.300	+/-0.010	0.297	✓		Vern	
Q	Ø0.188	+0.005 -0.001	Ø0.190	✓		Vern	
R							
S							
T							
U							
V							
W							
X							
Y							

Measured by: SAD	Audited by: 	Prototype Approval:	N/A
Date: 07/05/12	Date: 07.05.12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	